DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-000802
Date Inspected: 01-Nov-2007

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 600
OSM Departure Time: 1700
Location: Benicia, Ca.

CWI Name: William Norris

Inspected CWI report:	☑ Yes	☐ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Procedure Qualification

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector arrived at the Ironworkers Apprenticeship Training Facility and witnessed welding of a Procedure Qualification (PQR) test plate designated ABF-PQR-03-1-C using self shielded flux cored arc welding (FCAW) using Coreshield 8 electrode, .072 in. diameter. The welding was conducted with the support of a track guided “Bug O” system in the 4G (overhead) position. The welding was performed per the AWS D1.5, 2002 Section 5.13 requirements. The Smith Emery QC inspector, Mr. William Norris recorded the preheat and interpass temperatures, the average amperage, voltage and the travel speed for all weld passes. The QA inspector observed that the welder Mr. Daniel Gordon partially removed the third pass using a manual air-carbon arc gouging system. After the air-carbon arc cutting was complete, the weld groove was ground. After welding of the cover passes, the QC inspector Mr. Bill Norris identified an area of under fill at the end of the plate. This area was welded with the same parameters as the remainder of the weld without the support of a track guided system. The welding of this plate was completed on this date. The QA inspector noted that the welding appeared to comply with the contract documents.

Summary of Conversations:

At the start of welding the QC inspector reported that the Procedure Qualification test was to be performed in accordance with AWS D1.5-2002 section 5.13 and the maximum heat input would be used. Note: The term maximum heat input is being used by ABF for tests per 5.13 to qualify a larger welding parameter range and is not the maximum heat input test described in section 5.12. ABF intends on welding several PQR test plates per 5.13 using higher and lower heat inputs to acheive this. At the completion of the welding the QC inspector Mr. Morris reported that the test plate visual inspection would be performed at a later date.

During this visit, METS met with Mr. Bill Norris, Quality Control Inspector, of Smith Emery, Mr. James Bowers, Quality Control Manager of American Bridge / Fluor and Mr. Robert Mertz of Caltrans METS. The visual

inspection requirements of the contract special provisions and AWS D1.5-2002 were discussed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer